

Date: Wednesday, 12/14/2005 4:02:17 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|--|--|-----------------------|-----------------------|---------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : BASKET LID ASSEMBLY | | |
| Job Number | : 25233B | | | | | |
| Estimate Number | : 10207 | | | | | |
| P.O. Number | : N/A | | | Part Number | : D2989043 | |
| This Issue | : 12/14/2005 | | S.O. No. : N/A | Drawing Number | : D2989 REV B | |
| Prsht Rev. | : NC | | | Project Number | : N/A | |
| First Issue | : N/A | | Type : LARGE FAB ASSY | Drawing Revision | : B | |
| Previous Run | : 25232B | | | Material | : N/A | |
| Written By | : SEE COMMENT BELOW | | | Due Date | : 1/20/2006 | |
| Checked & Approved By | : SEE COMMENT BELOW | | | Qty: | 1 Um: Each | |
| Comment | : Est Rev:l Removed D2989-041 05-11-03 JLM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|-------------|
| 1.0 | D31821 | Hinge | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) | |
| | | Pick: | |
| | | Qty Part number Description Batch | |
| | | 2 D3182-1 Hinge B23085 | |
| | | | PD 06-01-11 |
| 2.0 | D34423 | Shim | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) | |
| | | Pick: | |
| | | Qty Part number Description Batch | |
| | | 2 D3442-3 Shim B23545 | |
| | | | PD 06-01-11 |
| 3.0 | M304EX07516F | Expanded Metal Flat Stai | |
| | | | |
| | | Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s) | |
| | | Pick: | |
| | | Qty Part number Description Batch | |
| | | 15sf M304EX0.75-16F Expanded Metal M19149 | |
| | | | PD 06-01-11 |
| 4.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W | |
| | | | |
| | | Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s) | |
| | | 3/4" x 3/4" x 0.063" wall 304/316 SStubing. | |
| | | Batch: B10447 | |
| | | | PD 06-01-11 |

| W/O: | | WORK ORDER CHANGES | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr |
| | | | | | | |
| | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 02/01/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 4:02:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 25233B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

PD 06-01-17

6.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DA 06/01/17

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

FC 06 01 18

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

ML 06 01 18

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1 06/01/19

Job Completion



4 06-01-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|------------------------------|---|--|
| DESIGN DS | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>HT</i> | APPROVED <i>HT</i> | DRAWING NO. D2989 | REV. B SHEET 1 OF 3 |
| DATE 05.06.07 | TITLE BASKET LID ASSEMBLY | | SCALE NTS |
| A | 00.10.27 | | NEW ISSUE |
| B | 05.06.07 | | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS |

RELEASED

05-08-19

PARTS LIST:

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------------------|
| X | | D2989-041 | BASKET LID ASSEMBLY (OUTSIDE) |
| | X | D2989-043 | BASKET LID ASSEMBLY (INSIDE) |
| | | | |
| 1 | | D2989-1 | STRUT |
| 1 | | D2989-2 | STRUT |
| 1 | | D2989-3 | STRUT |
| 1 | | D2989-4 | STRUT |
| 2 | | D2989-5 | STRUT |
| 2 | | D2989-7 | STRUT |
| 1 | | D2989-9 | STRUT |
| 1 | | D2989-10 | STRUT |
| 1 | | D2989-11 | STRUT |
| 1 | | D2989-12 | STRUT |
| 2 | | D2989-13 | STRUT |
| 2 | | D2989-15 | STRUT |
| | | | |
| 2 | | D2327-3 | SPACER BUSHING |
| 1 | | D2506 | LABEL PLATE |
| 2 | 2 | D2989-17 | STRUT (96.00" LONG) |
| 2 | | D2989-19 | STRUT (31.19" LONG) |
| 1 | | D2512-7 | STRUT |
| 2 | | D2581 | MOUNTING BRACKET |
| 2 | | D3182-1 | HINGE |
| 2 | | D3442-3 | SHIM |

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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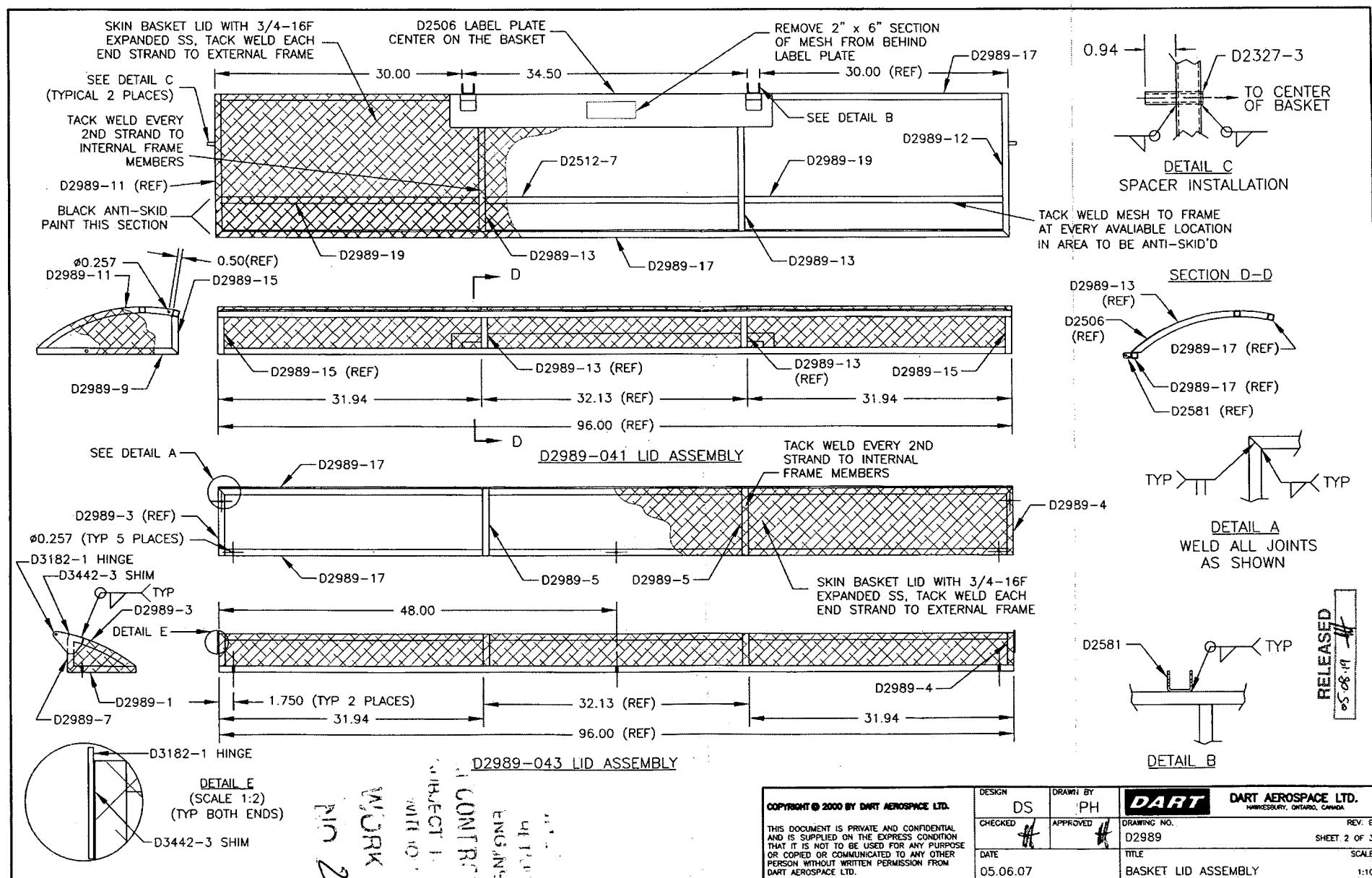
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SUBJECT TO

WITHHELD

WORK

NO. 25233B



| DESIGN | DRAWN BY | DART | | DART AEROSPACE LTD. |
|---------|----------|----------|----|-----------------------------|
| CHECKED | APPROVED | DS | PH | HAWKESBURY, ONTARIO, CANADA |
| | | | | REV. B |
| | | 05.06.07 | | SHEET 2 OF 3 |
| | | | | SCALE 1:10 |
| | | | | TITLE BASKET LID ASSEMBLY |

